

Friday, July 22, 2016 2:45:07 PM

AMOD

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[illegible]

Work Order ID 149438

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149438

Page 2

Item ID: D3560-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 9/6/2016 Start Qty: 7.00 ***7***

Cust Item ID:

Required Date: 9/15/2016 Req'd Qty: 7.00 ***7***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				7	0		DAS 49 9-89
130									16/08/16
QC	Memo	0.02							
Quality Control									
210	Identify as per dwg & Stock Location: _____	0.00							
210									
Packaging	Memo	0.01	DAS 6 9-89						AAUG162016
Packaging	LOCATION: WA003								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.12							
Quality Control									

DAS
21
9-89

AUG 17 2016

DAS
21
9-89 AUG 17 2016

Picklist Print

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Page 1

Work Order ID: 149438

149438

Parent Item: D3560-2

D3560-2

Parent Item Name: Arm

Start Date: 9/6/2016

Required Date: 9/15/2016

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A New Issue 06-11-10 JLM use -042
13.06.03 PER DWG REV.F DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X05.00 0		Purchased		No			f	29.9890		10.27895			

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	3.497	
m134514	0.667	
nm134533	2.83	
MAT001	26.492	
m130527	1.545	
m131392	0.947	
m134984	24	

M135377 → 10.28

DAS
14
9-09

16/08/07

DART AEROSPACE LTD		Work Order:	149428
Description: Arm		Part Number:	D3560-2
Inspection Dwg: D3560 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

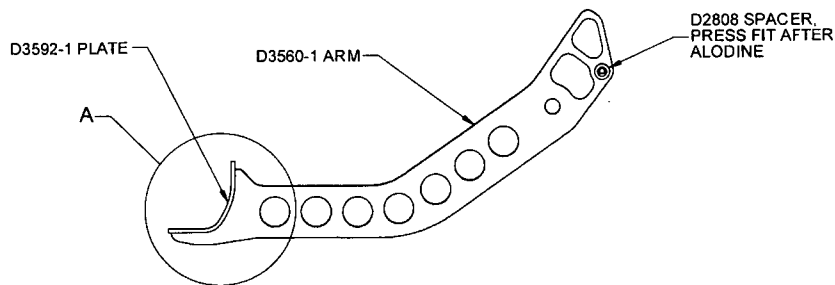
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5065	✓		Vern	FK-04
Ø0.196	+0.005/-0.001	.196	✓		"	"
Ø1.000	+0.010/-0.001	1.002	✓		"	"
0.500	+/-0.010	.502	✓		"	"
0.250	+/-0.010	.249	✓		"	"
0.275	+/-0.010	.272	✓		"	"
0.188	+/-0.010	.188	✓		"	"
2.000	+/-0.010	2.001	✓		"	"
1.700	+/-0.010	1.701	✓		"	"
Ø0.385 x 100°	+/-0.010 x 0.5°	0.366	✓		caliper	JCL-08
0.250 Deep	+/-0.010	.254	✓		Vern	FK-04

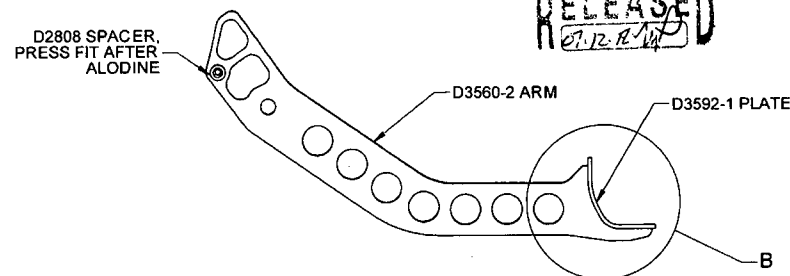
Measured by:	DAS 44 9-89	Audited by:	DAS 49 9-89	Prototype Approval:	N/A
Date:	16-08-15 16-08-15	Date:	16/08/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-042	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	09.06.11	Dwg Rev updated	KJ	

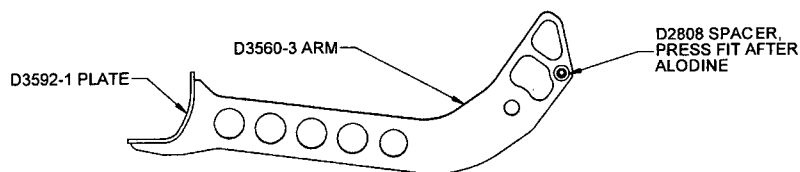
RELEASED
07.12.16



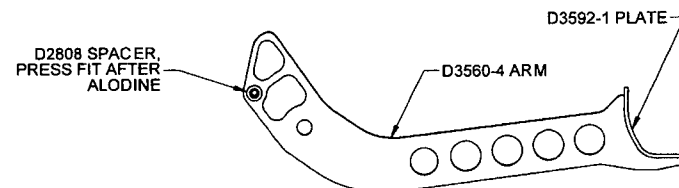
D3560-041 ARM WELDMENT



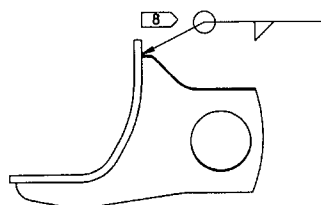
D3560-042 ARM WELDMENT



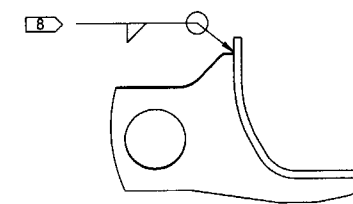
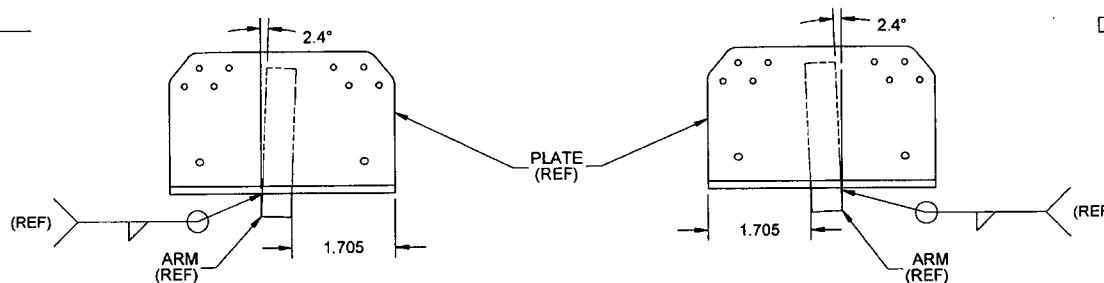
D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



**DETAIL A
SCALE 1 : 2**



**DETAIL B
SCALE 1 : 2**

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.23 lbs (TYP)
 8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.08.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

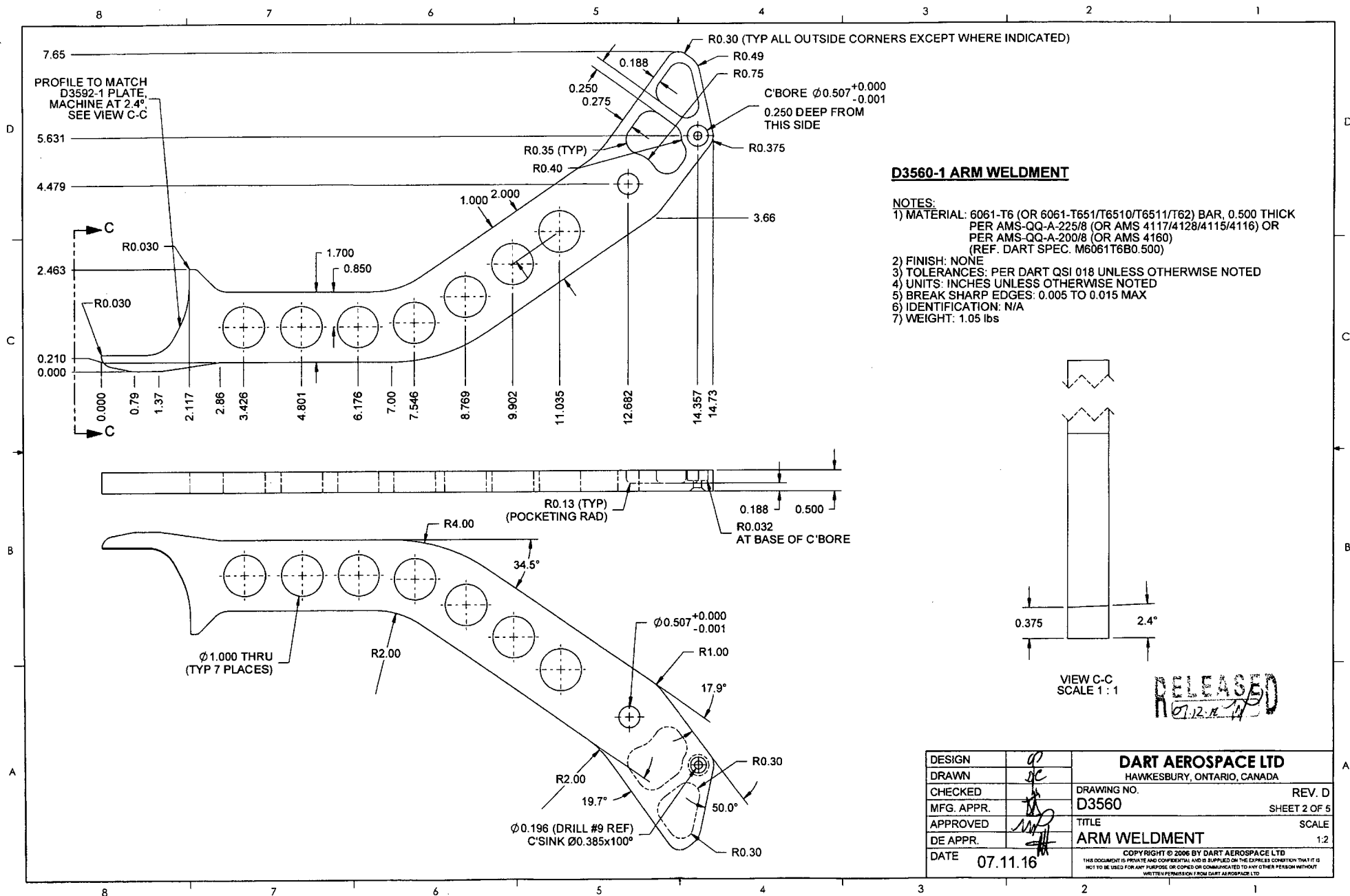
DRAWING NO. **D3560** REV. D
SHEET 1 OF 5

TITLE **ARM WELDMENT** SCALE 1:4

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w/o 149438

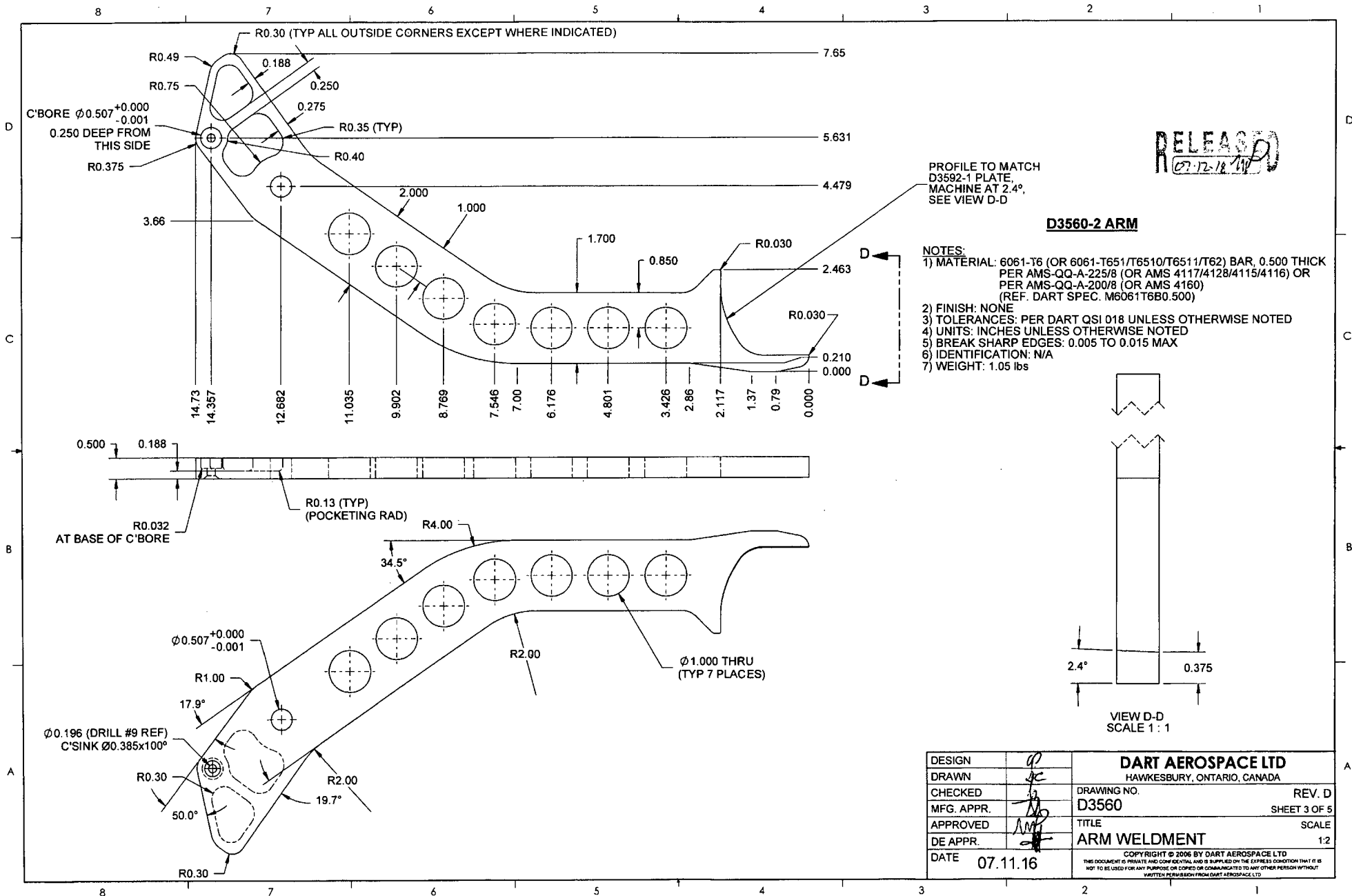
2m 16/07/25

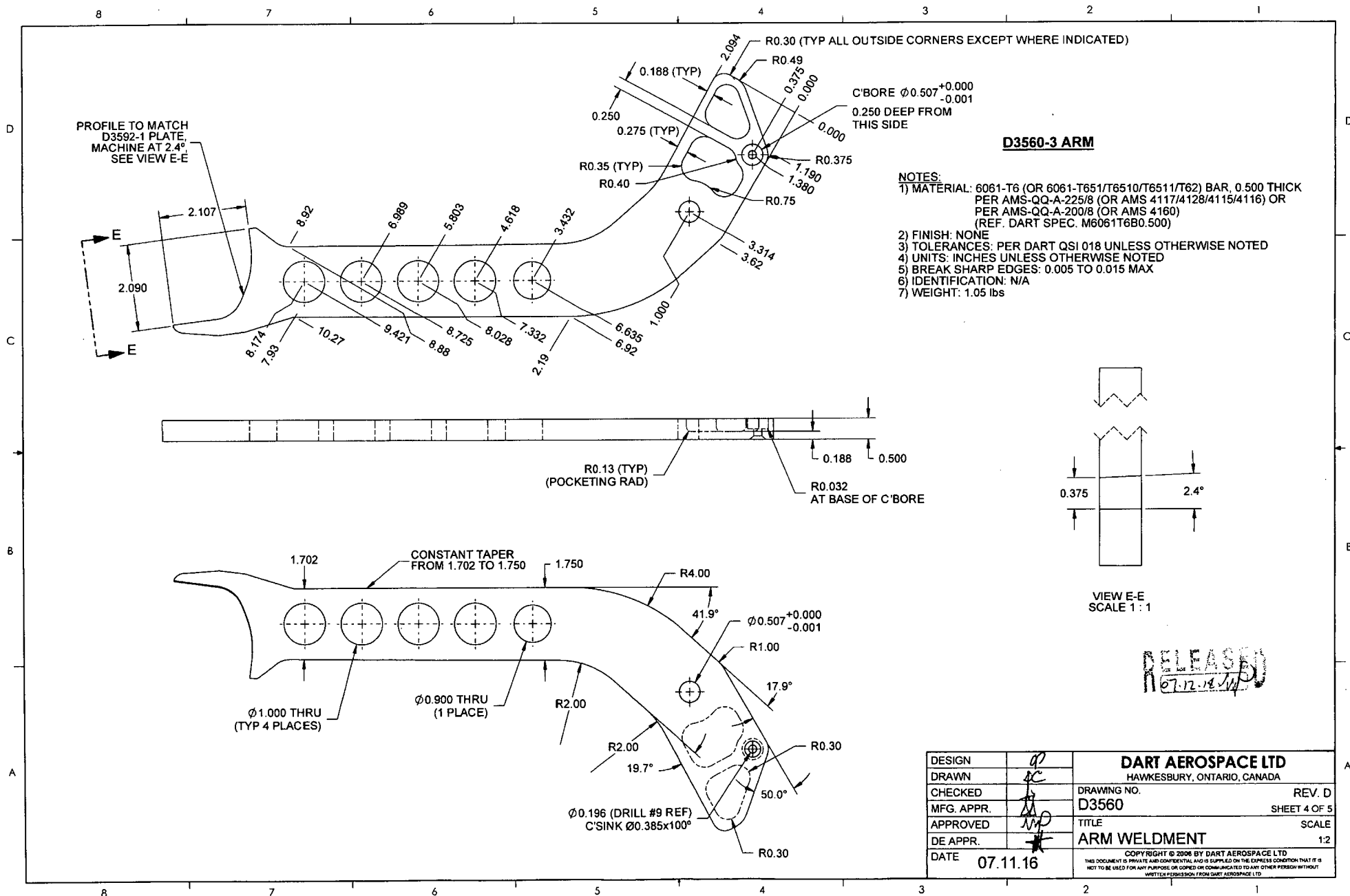


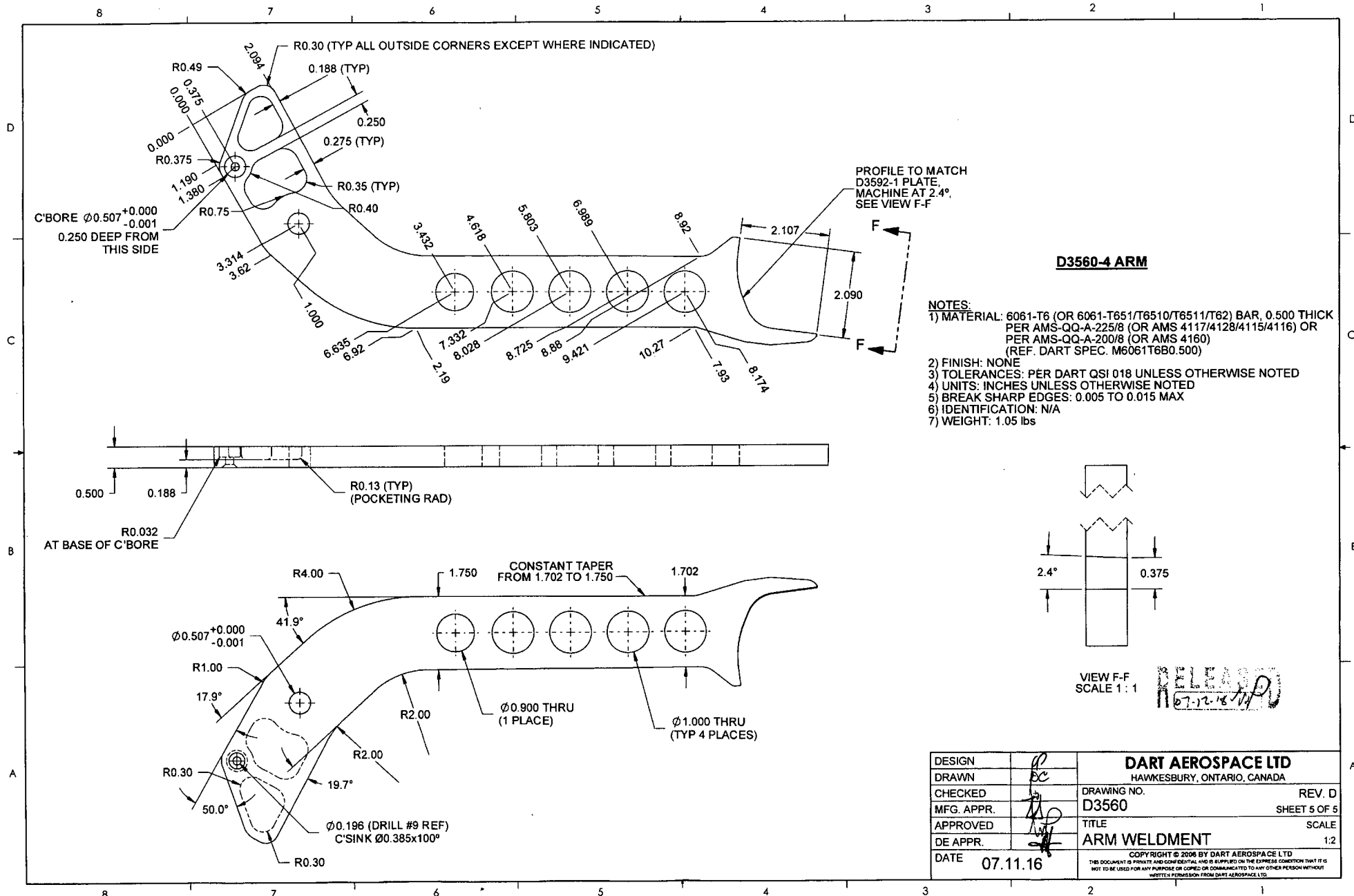
D3560-1 ARM WELDMENT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6511/T62) BAR, 0.500 THICK
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 (REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

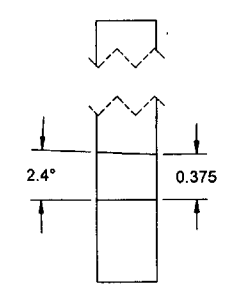






D3560-4 ARM

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1:1

RELEASED
07-12-16

DESIGN		DART AEROSPACE LTD	
DRAWN	EC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
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